

**(QUALITY ASSURANCE PAM 702-101)**

**INSTRUCTIONS:** USE SYMBOLS IN ACCORDANCE WITH ANSI Y 16.5  
**LEGEND:** MANDATORY REQUIREMENTS    ● - LOCATING DATA    ▲ - MEASURING POINT    ■ - USE EXPANDED SERVICES

## GEAR INSPECTION METHODS

(X) SPUR (-) HELICAL (X) EXTERNAL (-) INTERNAL

**COMPOSITE METHOD OF INSPECTION WITH MASTER**

COMPOSITE METHOD OF INSPECTION REQUIRES ROLLING PART GEARS IN TIGHT MESH WITH A MASTER GEAR ON A VARIABLE CENTER DISTANCE FIXTURE OR GEAR ROLLING MACHINE EQUIPPED WITH INDICATING DEVICE OR RECORDER.

**(X) WHEN DEFINED ON DRAWING:**

WHEN COMPOSITE TOLERANCES ARE DEFINED ON DRAWING THE VALUES WILL BE THE MANDATORY CRITERIA FOR ACCEPTANCE OR REJECTION OF PART GEARS.

(3)	TOOTH TO TOOTH COMPOSITE TOLERANCE	.0021
(X)	TOTAL COMPOSITE TOLERANCE	.0044

(-) WHEN NOT DEFINED ON DRAWING:

( ) METHOD A: ESTABLISH TOTAL COMPOSITE TOLERANCE BY ROLLING TEN ANALYTICALLY INSPECTED AND ACCEPTED PART GEARS WITH A MASTER GEAR.

( ) METHOD B: CALCULATE TOTAL COMPOSITE TOLERANCE USING 60% OF SUM TOTAL OF PROFILE, PITCH, AND RUNOUT TOLERANCES.

TOTAL COMPOSITE TOLERANCE \_\_\_\_\_

**NOTES:**

1. IN ADDITION TO COMPOSITE INSPECTION, METHOD A OR B, ONE GEAR FROM EACH LOT SHALL BE ANALYTICALLY INSPECTED.
2. WHEN PART GEARS EXCEED THE LIMITS ESTABLISHED BY METHOD A OR B, ACCEPTANCE SHALL BE PREDICATED ON ANALYTICAL INSPECTION. PART GEARS ACCEPTED BY ANALYTICAL INSPECTION MAY BE USED TO RE-ESTABLISH LIMITS OF METHOD A OR B.

**ANALYTICAL INSPECTION**

(-)	PROFILE TOLERANCE.			
(-)	ZERO AT	DIAMETER		
(X)	PITCH TOLERANCE (TOOTH TO TOOTH)			-0021
(-)	INDEX TOLERANCE (ANY TWO TEETH)			
(X)	RUNOUT, PITCH DIAMETER TO MOUNTING AXIS			-0044
(-)	LEAD TOLERANCE ACROSS FACE WIDTH			
(-)	TOOTH CROWN			
(X)	ARC TOOTH THICKNESS			-0491/-0475
(X)	MEASUREMENT (X) OVER (-) BETWEEN			
(X)	ONE (-) TWO .0540	DIAMETER		
(X)	WIRES (-) BALLS			.2216/.2276

LEGEND: (X) APPLICABLE (-) NOT APPLICABLE

QAR REVISION SYMBOL & DATE	Ø10-25-79 MT	CONTACTS/INSTRUMENTS	gas meter
		202	12279013
			PALE REPORT

DAAE20-01-C-0009

## Modification P00002

# Attachment 01

GUNNERS AUXILIARY SIGHT(9377915)  
(PACKAGE IAW BEST COMMERCIAL PRACTICE, ASTM-D3951)  
(SUITABLE FOR OVERSEAS SHIPMENT).

CLEAN ASSEMBLY. PROTECT EXPOSED OPTICAL SURFACES WITH  
TISSUE AND CAP PLUGS. BAG INSTRUMENT, BROW REST,  
LINK, AND HARDWARE. PACKAGE ITEMS USING MOLDED FOAM  
PACKAGING. CLOSE AND LABEL FOR SHIPMENT. PALLETIZE UNITS.

DETAIL PROCEDURES:

1. CLEAN EXPOSED SURFACES OF OPTICAL ELEMENTS PER  
20.2.2.1.8.2 OF APPENDIX F, MIL-STD-2073-1A.  
CLEAN ALL OTHER SURFACES PER PROCESS C-1 OF  
MIL-P-116.
2. COVER OPTICAL SURFACES WITH FOUR LAYERS LENS  
TISSUE (A-A50177, TY II) AND SECURE WITH MASKING TAPE  
(A-A-883, TY II).
3. COVER OBJECTIVE CELL ASSEMBLY WITH CAPLUG(MS90376-44R),  
AND SECURE WITH MASKING TAPE.
4. COVER ELECTRICAL CONNECTOR J1 WITH EP-10 CAPLUG(MS90376-10Y).
5. REMOVE AND BAG BROW REST:

REMOVE BROW REST BY LOOSENING THE KNOB, AND THEN  
RE-TIGHTEN KNOB AFTERWARDS.

DUST BROW REST WITH TALC (MIL-T-50036), AND PLACE IN  
10x10 BAG (MIL-B-117, TY I, CL B, ST 2). HEAT SEAL  
BAG TO CLOSE.

AFFIX UNIT LABEL (MIL-STD-129) TO IDENTIFY THE BROW  
REST (12278904).

6. PLACE CONNECTING LINK (12278963) IN 24x3 BAG (MIL-B-117,  
TY I, CL B, ST 2)AND HEAT SEAL BAG.
7. BAG REMAINING HARDWARE:

CONTENTS OF EACH BAG SHALL BE:

MS20392-5C41	PIN	2 EA.
MS24665-317	PIN	2 EA.
MS35333-42	WASHER	6 EA.
B1821BH038C150N	SCREW	6 EA.
12278978	PLUG	1 EA.

12278979	PLUG	1 EA.
12279017	WASHER	3 EA.

PLACE HARDWARE IN 8x8 BAG (MIL-B-117, TY I, CL B, ST 2),  
AND HEAT SEAL BAG.

AFFIX ITEMIZED UNIT LABEL TO BAG.

8. PLACE ONE SIGHT (9377915) IN 25x52 HEAT SEAL  
BAG (MIL-B-117, TY I, CL E, ST 1).

AFFIX UNIT LABEL (MIL-STD-129) TO IDENTIFY AS THE  
GUNNERS AUXILIARY SIGHT (9377915).

9. PLACE MOLDED LOWER CUSHION IN 48X18X18 BOX (ASTM-<sup>5118</sup>~~D3951~~).  
PLACE SIGHT IN CENTER CAVITY, INCLUDE  
SMALL BAGGED ITEMS. BROW REST, LINK, AND HARDWARE INTO  
CAVITIES.

PLACE MOLDED UPPER CUSHION OVER THE ITEMS. .45 - .55 density lb/cu - ft.,  
Polymeric MDI/Polyurethane Foam  
IMMOBILIZE. CLOSE AND SECURE BOX WITH WATERPROOF TAPE Resin Mixture  
(PPP-T-60). BAND, TWO PLACES AROUND GIRTH.

9. AFFIX EXTERIOR LABEL (MIL-STD-129), BARCODE LABEL  
AND ADDRESS LABEL TO BOX.

NSN: 1240-01-259-9096  
CAGE/PRIME: 19200  
PN/PRIME: 9377915  
CAGE/MFR: 32865  
PN/MFR: 9377915  
DESCRIPTION: GUNNERS AUXILIARY SIGHT  
CONTRACT NO: DAAE20-01-C-0009

10. PALLETIZE BOXES FOR SHIPMENT.